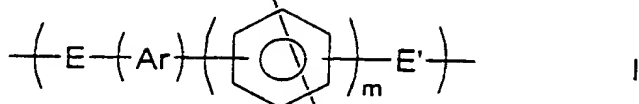
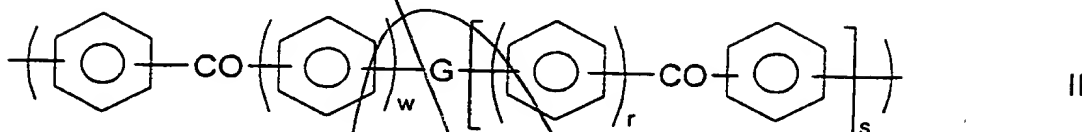


## CLAIMS

1. A polymer electrolyte membrane which includes a  
5 polymer having a moiety of formula



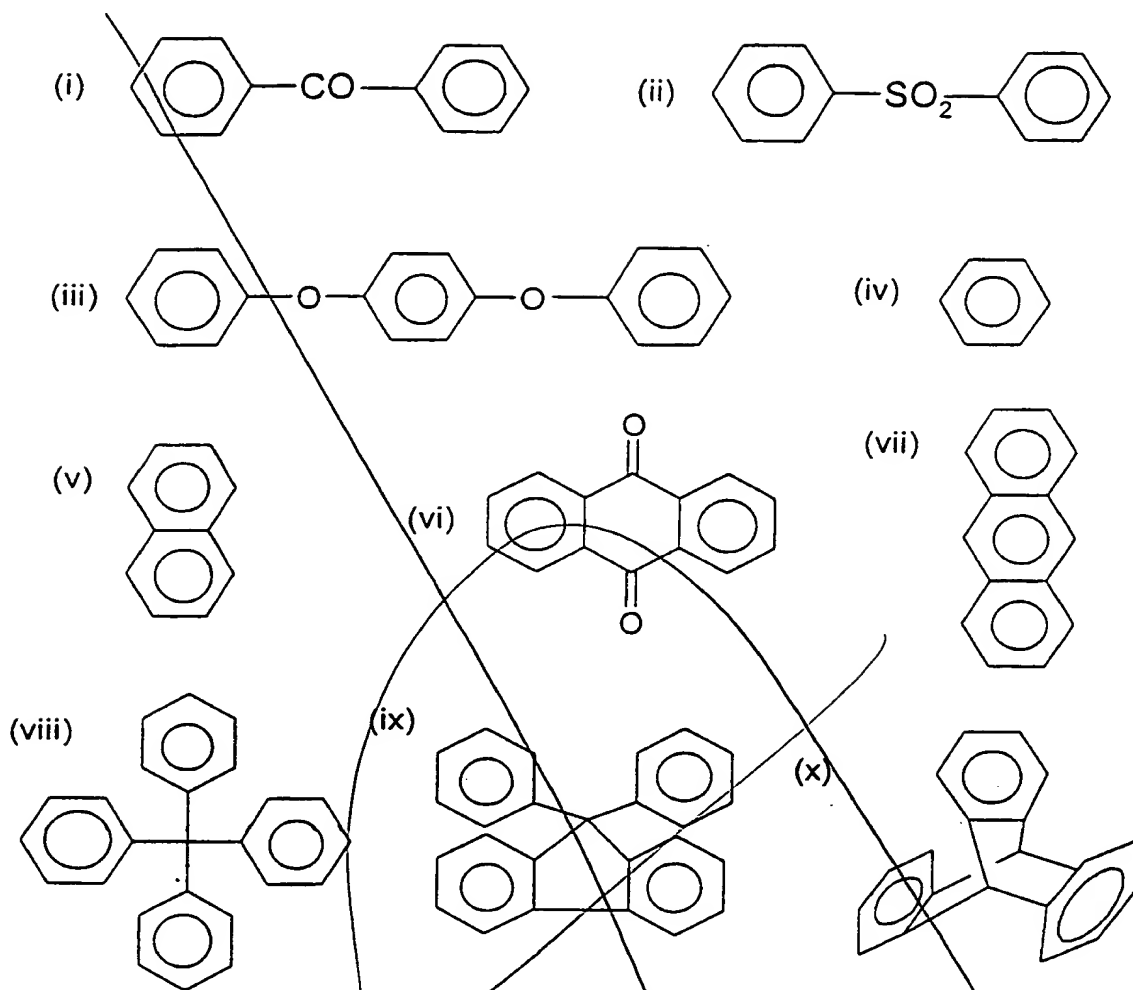
and/or a moiety of formula



10 and/or a moiety of formula



wherein at least some of the units I, II, and/or III are sulphonated; wherein the phenyl moieties in units I, II and III are independently optionally substituted and  
15 optionally cross-linked; and wherein m, r, s, t, v, w and z independently represent zero or a positive integer, E and E' independently represent an oxygen or a sulphur atom or a direct link, G represents an oxygen or a sulphur atom, a direct link or a -O-Ph-O- moiety where Ph represents a  
20 phenyl group and Ar is selected from one of the following moieties (i) to (x) which is bonded via one or more of its phenyl moieties to adjacent moieties



2. A polymer electrolyte membrane which includes a polymer having a moiety of formula I and/or a moiety of formula II and/or a moiety of formula III as described in claim 1, wherein at least some of units I, II and/or III are functionalized to provide ion exchange sites.

3. A membrane according to claim 1 or claim 2, wherein said polymer is crystalline.

4. A membrane according to any preceding claim, wherein "a" represents the mole % of units of formula I in said

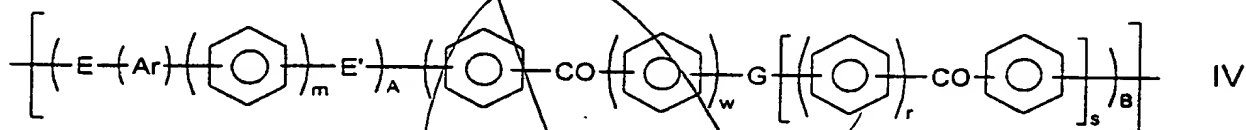
polymer; "b" represents the mole % of units of formula II in said polymer; and "c" represents the mole % of units of formula III in said polymer and wherein a is in the range 45-100 and the sum of b and c is in the range of 0-55.

5

5. A membrane according to any preceding claim, wherein said polymer consists essentially of moieties I, II and/or III.

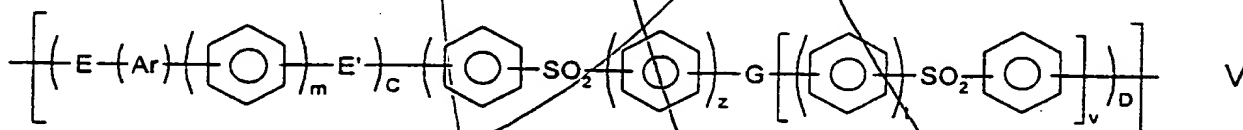
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6. A membrane according to any preceding claim, wherein said polymer is a homopolymer having a repeat unit of general formula



15

or a homopolymer having a repeat unit of general formula



or a random or block copolymer of at least two different units of IV and/or V

20

wherein A, B, C and D independently represent 0 or 1.

7. A membrane according to claim 6, wherein said polymer includes at least one repeat unit of formula IV.

25

8. A membrane according to claim 6, wherein said polymer is a copolymer comprising a first repeat unit of formula

IV wherein E and E' represent oxygen atoms, G represents a direct link, Ar represents a moiety of structure (iv), m represents 1, w represents 1, s represents zero, A and B represent 1; and

5

a second repeat unit of formula V wherein E and E' represent oxygen atoms, Ar represents a structure (i), m represents 0, C represents 1, z represents 1, G represents a direct link, v represents 0 and D represents 1.

10

9. A membrane according to claim 6, wherein said polymer is a copolymer comprising a first repeat unit of formula IV, wherein E and E' represent oxygen atoms, G represents a direct link, Ar represents a moiety of structure (iv), m represents 1, w represents 1, s represents 0, A and B represent 1.

10. A membrane according to claim 6, wherein said polymer is a copolymer comprising a first repeat unit of formula IV wherein E and E' represent oxygen atoms, G represents a direct link, Ar represents a moiety of structure (iv), m represents 1, w represents 1, s represents 0, A and B represent 1; and a second repeat unit of formula IV wherein E represents an oxygen atom, E' represents a direct link, Ar represents a moiety of structure (i), m represents zero, A represents 1, B represents 0.

11. A membrane according to claim 6, wherein said polymer is a copolymer comprising a first repeat unit which is either:

30

(a') of formula IV wherein E and E' represent oxygen atoms, G represents a direct link, Ar represents a

moiety of structure (iv), m and s represent zero, w represents 1 and A and B represent 1; or

(b') of formula IV wherein E represents an oxygen atom, E' represents a direct link, Ar represents a moiety of structure (i), m represents zero, A represents 1, B represents zero;

and a second repeat unit which is either:

(c') of formula IV wherein E and E' represent oxygen atoms, G represents a direct link, Ar represents a moiety of structure (iv), m represents 1, w represents 1, s represents zero, A and B represent 1; or

(d') of formula IV wherein E represents an oxygen atom, E' is a direct link, G represents a direct link, Ar represents a moiety of structure (iv), m and s represent zero, w represents 1, A and B represent 1.

12. A membrane according to claim 11, wherein said polymer has a repeat unit as described in paragraph (a') or (b') in combination with a repeat unit as described in paragraph (c').

13. A membrane according to claim 6, comprising a first repeat unit which is selected from the following:

(a) a unit of formula IV wherein E and E' represent oxygen atoms, G represents a direct link, Ar represents a moiety of structure (iv), m and s represent zero, w represents 1 and A and B represent 1;

(b) a unit of formula IV wherein E represents an oxygen atom, E' represents a direct link, Ar represents a moiety of structure (i), m represents zero, A represents 1, B represents zero;

(c) a unit of formula V wherein E and E' represent oxygen atoms, G represents a direct link, Ar represents a moiety of structure (iv), m and v represent zero, z represents 1 and C and D represent 1;

(d) a unit of formula V wherein E represents an oxygen atom, E' represents a direct link, Ar represents a moiety of structure (ii), m represents 0, C represents 1, D represents 0; or

(e) a unit of formula V wherein E and E' represents an oxygen atom, Ar represents a structure (i), m represents 0, C represents 1, Z represents 1, G represents a direct link, v represents 0 and D represents 1;

and a second repeat unit which is selected from the following:

(f) a unit of formula IV wherein E and E' represent oxygen atoms, G represents a direct link, Ar represents a moiety of structure (iv), m represents 1, w represents 1, s represents zero, A and B represent 1;

(g) a unit of formula IV wherein E represents an oxygen atom, E' is a direct link, G represents a direct link, Ar represents a moiety of structure (iv), m and s represent zero, w represent 1, A and B represent 1;

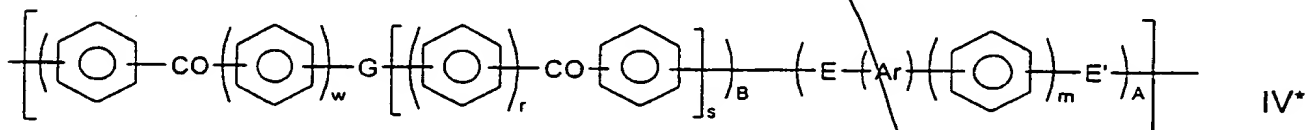
(h) a unit of formula V wherein E and E' represent oxygen atoms, G represents a direct link, Ar represents a moiety of structure (iv), m represents 1, z represents 1, v represents 0, C and D represent 1; and

(i) a unit of formula V wherein E represents an oxygen atom, E' represents a direct link, G represents a direct link, Ar represents a moiety of structure (iv), m and v represent zero, z represents 1, C and D represent 1;

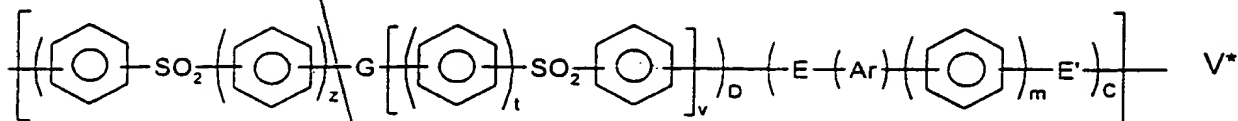
14. A membrane according to any of claims 6 to 13, wherein said second unit is selected from a unit of formula IV wherein E and E' represent oxygen atoms, G represents a direct link, Ar represents a moiety of structure (v), m represents 0, w represents 1, s represents 0, A and B represent 1; or a unit of formula V wherein E and E' represent oxygen atoms, G represents a direct link, Ar represents a moiety of structure (v), m represents 0, z represents 1, v represents 0, c and d represent 1.

15. A membrane according to claim 13 or claim 14, wherein said copolymer has a first repeat unit selected from units (b), (d) or (e) in combination with a second repeat unit selected from units (f) or (h).

16. A membrane according to any of claims 1 to 5, wherein said polymer is a homopolymer having a repeat unit of general formula



or a homopolymer having a repeat unit of general formula



5 or a random or block copolymer of at least two different units of IV\* and/or V\* wherein A, B, C and D independently represent 0 or 1.

10 17. A membrane according to claim 16, wherein said polymer includes: a repeat unit of formula IV\* wherein E represents a direct link, E' represents an oxygen atom, G represents a direct link, w, s and m represent 0, A and B represent 1; and/or a repeat unit of formula V\* wherein E represents a direct link, E' represents an oxygen atom, G represents a direct link, z, v and m represent 0, C and D represent 1.

18. A membrane according to claim 17 which includes a repeat unit of formula IV\* or V\* and any of units (a) to 20 (i) according to claim 13.

19. A membrane according to any preceding claim, wherein said polymer includes at least some ketone moieties in the polymeric chain.

25

20. A membrane according to any preceding claim, wherein said polymer includes a biphenylene moiety.

21. A membrane according to any preceding claim, wherein said polymer includes a -O-biphenylene-O- moiety.

22. A membrane according to any preceding claim, wherein  
5 said polymer includes a -O-naphthalene-O-moiety.

23. A membrane according to any preceding claim, wherein said polymer has a glass transition temperature (T<sub>g</sub>) of at least 144°C.

24. A membrane according to claim 23, wherein said glass transition temperature is at least 154°C.

25. A membrane according to any preceding claim, wherein  
15 said polymer has an inherent viscosity of at least 0.3.

26. A membrane according to any preceding claim, for a fuel cell.

20 27. A membrane according to any preceding claim, for an electrolyser.

28. A fuel cell incorporating a polymer electrolyte membrane according to any of claims 1 to 25.

29. An electrolyser incorporating a polymer electrolyte membrane according to any of claims 1 to 25.

30. A gas diffusion electrode incorporating a polymer  
30 electrolyte membrane according to any of claims 1 to 25.

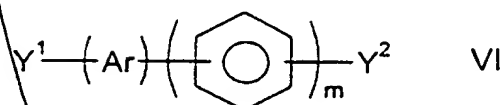
31. A novel polymer as described in any of claims 1 to 25  
per se.

1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	2101	2102	2103	2104	2105	2106	2107	2108	2109	2110	2111	2112	2113	2114	2115	2116	2117	2118	2119	2120	2121	2122	2123	2124	2125	2126	2127	2128	2129	2130	2131	2132	2133	2134	2135	2136	2137	2138	2139	2140	2141	2142	2143	2144	2145	2146	2147	2148	2149	2150	2151	2152	2153	2154	2155	2156	2157	2158	2159	2160	2161	2162	2163	2164	2165	2166	2167	2168	2169	2170	2171	2172	2173	2174	2175	2176	2177	2178	2179	2180	2181	2182	2183	2184	2185	2186	2187	2188	2189	2190	2191	2192	2193	2194	2195	2196	2197	2198	2199	2200	2201	2202	2203	2204	2205	2206	2207	2208	2209	2210	2211	2212	2213	2214	2215	2216	2217	2218	2219	2220	2221	2222	2223	2224	2225	2226	2227	2228	2229	2230	2231	2232	2233	2234	2235	2236	2237	2238	2239	2240	2241	2242	2243	2244	2245	2246	2247	2248	2249	2250	2251	2252	2253	2254	2255	2256	2257	2258	2259	2260	2261	2262	2263	2264	2265	2266	2267	2268	2269	2270	2271	2272	2273	2274	2275	2276	2277	2278	2279	2280	2281	2282	2283	2284	2285	2286	2287	2288	2289	2290	2291	2292	2293	2294	2295	2296	2297	2298	2299	2300	2301	2302	2303	2304	2305	2306	2307	2308	2309	2310	2311	2312	2313	2314	2315	2316	2317	2318	2319	2320	2321	2322	2323	2324	2325	2326	2327	2328	2329	2330	2331	2332	2333	2334	2335	2336	2337	2338	2339	2340	2341	2342	2343	2344	2345	2346	2347	2348	2349	2350	2351	2352	2353	2354	2355	2356	2357	2358	2359	2360	2361	2362	2363	2364	2365	2366	2367	2368	2369	2370	2371	2372	2373	2374	2375	2376	2377	2378	2379	2380	2381	2382	2383	2384	2385	2386	2387	2388	2389	2390	2391	2392	2393	2394	2395	2396	2397	2398	23
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32. A process for the preparation of a polymer as described in any of claims 1 to 25, the process comprising:

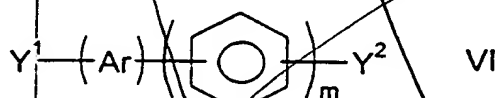
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(a) polycondensing a compound of general formula



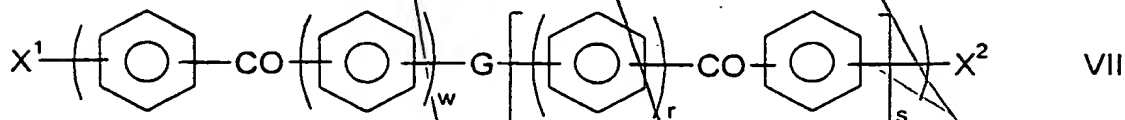
with itself wherein  $Y^1$  represents a halogen atom or a group -EH and  $Y^2$  represents a halogen atom or, if  $Y^1$  represents a halogen atom,  $Y^2$  represents a group E'H; or

(b) polycondensing a compound of general formula

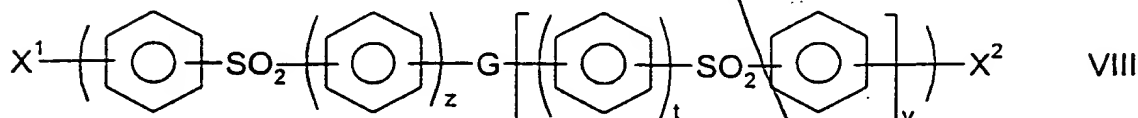


15

with a compound of formula



and/or with a compound of formula



wherein  $Y^1$  represents a halogen atom or a group -EH (or -E'H if appropriate) and  $Y^2$  represents a halogen atom or a group -E'H and  $X^2$  represents the other one of a halogen atom or a group -E'H (or EH of appropriate); and

(c) optionally copolymerizing a product of a process as described in paragraph (a) with a product of a process as described in paragraph (b);

10

wherein the phenyl moieties of units VI, VII and/or VIII are optionally substituted; the compounds VI, VII and/or VIII are optionally sulphonated; and Ar, m, w, r, s, z, t, v, G, E and E' are as described in any of claims 1 to 20 except that E and E' do not represent a direct link; the process also optionally comprising sulphonating and/or cross-linking a product of the reaction described in paragraphs (a), (b) and/or (c) to prepare said polymer.

33. A process according to claim 31, wherein sulphonation is carried out in concentrated sulphuric acid at an elevated temperature.

34. A novel polymer as described in any of claims 1 to 24 (except that the polymer is not sulphonated) per se.

35. A membrane, a fuel cell, a process, a novel polymer, each being independently substantially as hereinbefore described, with reference to the examples.